

Date: Wednesday, 3/14/2007 3:31:50 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG ASSEMBLY
<b>Job Number</b> : 31226	
<b>Estimate Number</b> : 10012	
<b>P.O. Number</b> : <i>NIA</i>	<b>Part Number</b> : D27363
<b>This Issue</b> : 3/14/2007 <b>S.O. No.</b> : <i>NIA</i>	<b>Drawing Number</b> : D2736 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 3/14/2007 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 30053	<b>Material</b> : <i>NIA</i>
<b>Written By</b> : <i>KJ 07.03.15</i>	<b>Due Date</b> : 4/6/2007
<b>Checked &amp; Approved By</b> : <i>KJ 07.03.15</i>	<b>Qty:</b> 40 <b>Um:</b> Each
<b>Comment</b> : Est Rev: D Removed from 9 digit 05-10-25 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2591	Lug
-----	-------	-----



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2591	Lug	

*B3348 x5*  
*B31231 x20*

*B28022 x1**B30056 x12**FC 07/06/04 (38)*

2.0	D27353	Lug Bracket
-----	--------	-------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2735-3	Lug Bracket	

*B31233**FC 07/06/04**(38)*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

Weld D2591 &amp; D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: *M103794**FC 07/06/05 (38)*

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



**Comment:** VISUAL WELDING INSPECTION

*FC 07/06/05 (38)*

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

*FC 07/06/05 (38)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:31:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 31226

Part Number: D27363

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*M 104144*



*38x*

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

*BR/SEL.*

*07-06-08*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*38x*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L*

*07/06/08*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SF 406*

*CV*

*7/6/9*

*SP*

*38x*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*38*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/11*

Job Completion



*h A-16-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

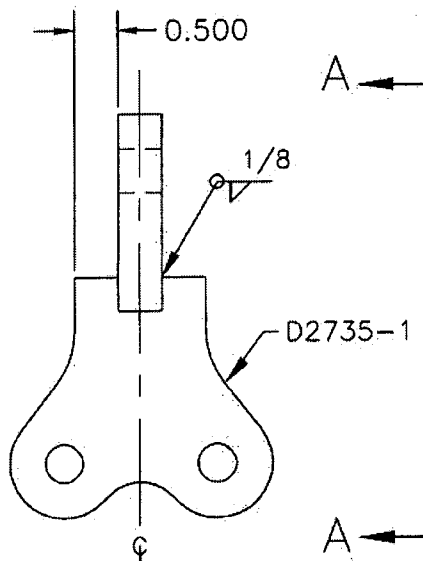
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

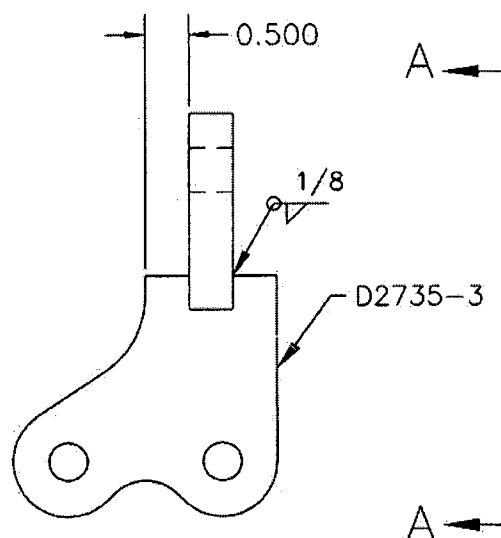
NOTE: Date & initial all entries



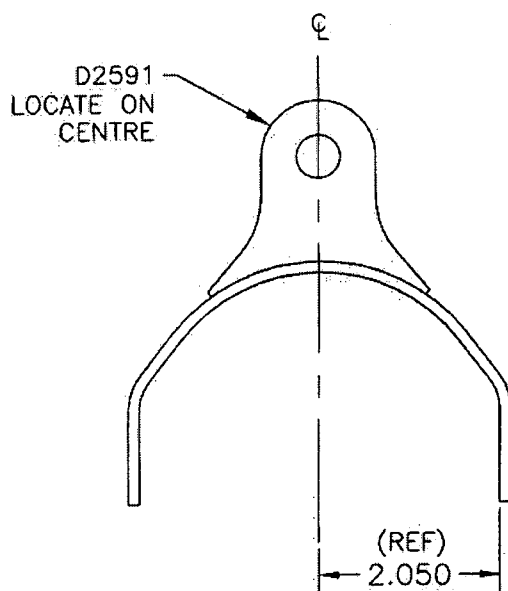
DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KA</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

RELEASED  
97/12/24 DS

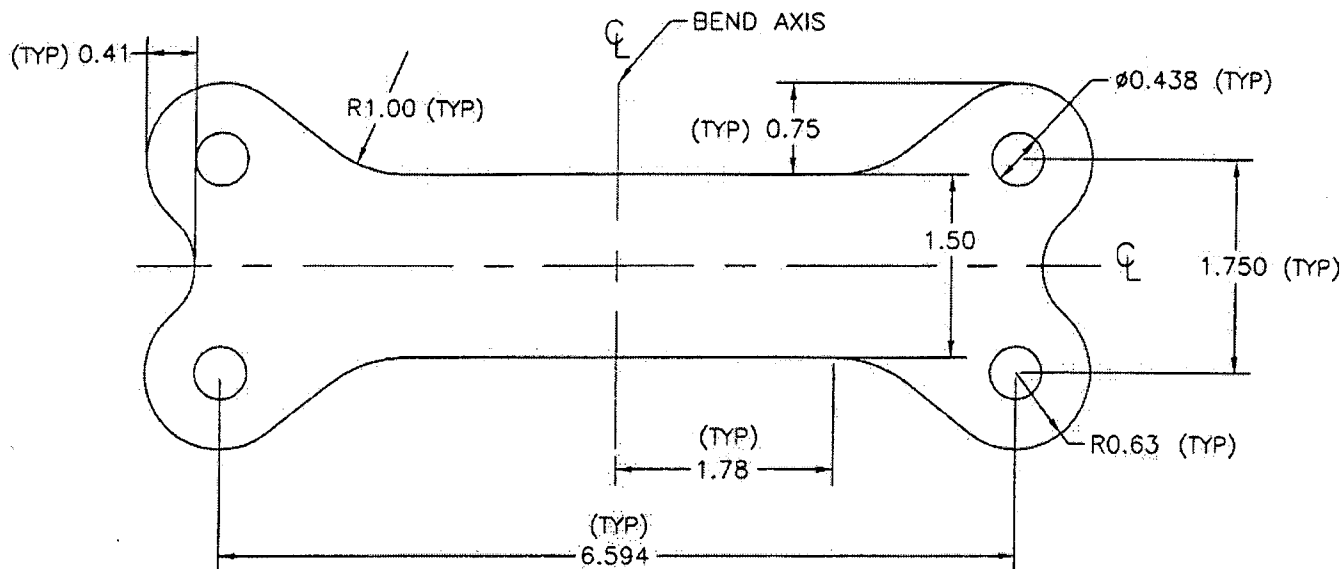
ELN 057

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31226

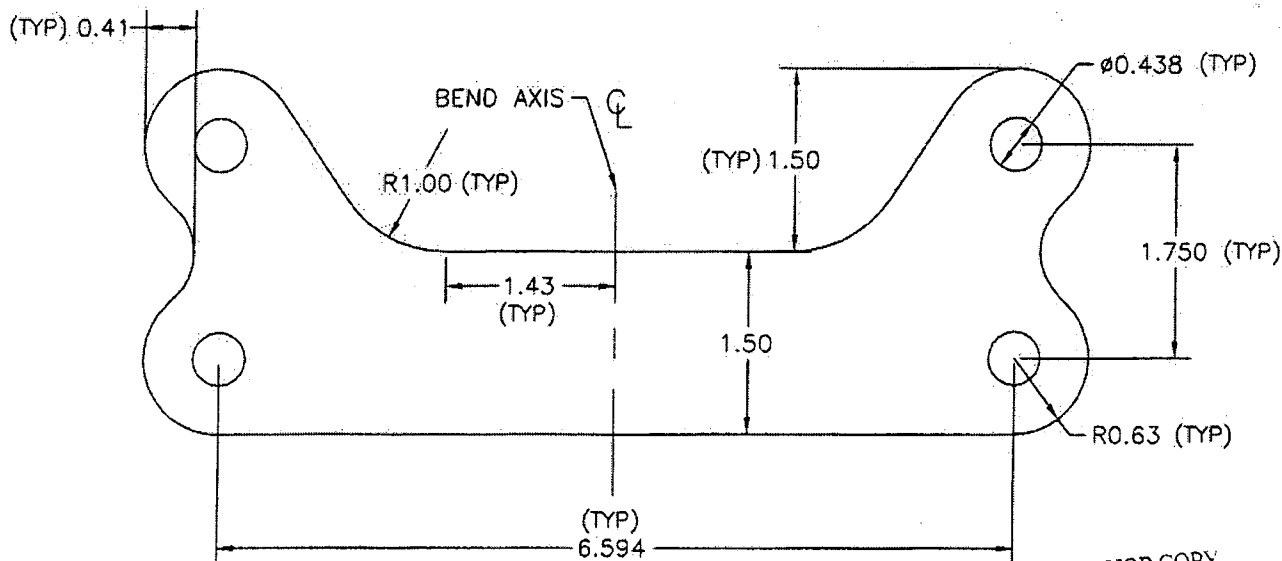


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14	TITLE LUG BRACKET		SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED  
98.12.14 DS



D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES ( $\phi$ )

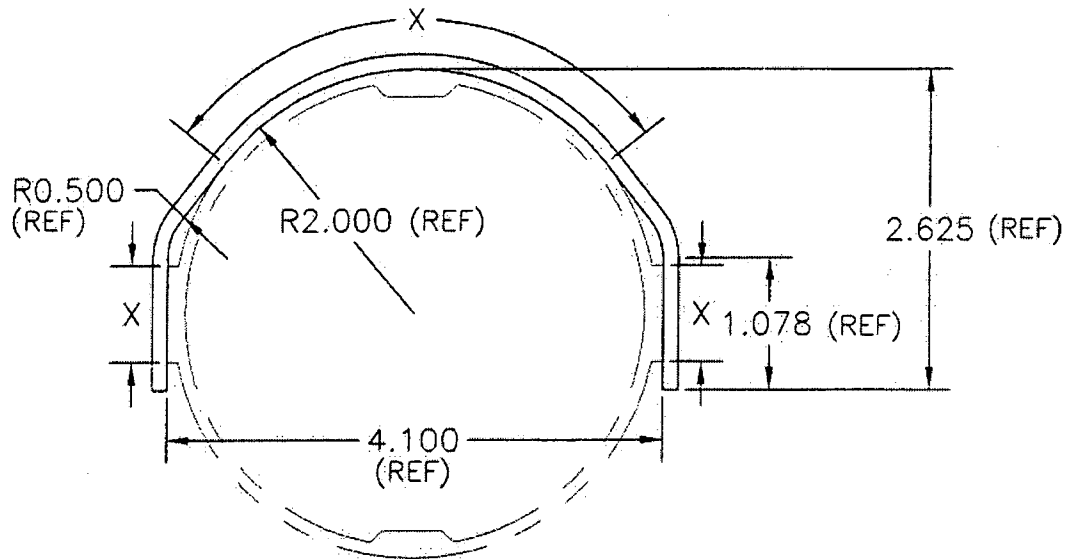


D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE ( $\phi$ )

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31226

**DART**

DESIGN #1	DRAWN BY #1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

**RELEASED**  
98.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31226